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D3913-041
Job Sheet 188195



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 3/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/4/19	3/4/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	1 pcs	3/4/19	3/4/19	0.00	10.00	Large Fab 1		
110	QC	1 pcs	3/4/19	3/4/19	0.00	0.00	QC9		
120	QC	1 pcs	3/4/19	3/4/19	0.00	0.00	QC5		
125	HandFinish	1 pcs	3/4/19	3/4/19	0.00	0.29	HandFinish2		
130	Powdercoat	1 pcs	3/4/19	3/4/19	0.00	0.93	Powdercoat2		
135	Packaging	1 pcs	3/4/19	3/4/19	0.00	0.00	Packaging1		
140	QC	1 pcs	3/4/19	3/4/19	0.00	0.00	QC3		
150	HandFinish	1 pcs	3/4/19	3/4/19	0.00	0.50	HandFinish4		
160	QC	1 pcs	3/4/19	3/4/19	0.00	0.00	QC5		
170	Packaging	1 pcs	3/4/19	3/4/19	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea	3/4/19	3/4/19	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M138997 START: 10:00 TEMP: 400° FINISH: 10:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	90-Start up Operation	5125 289
D3913-1 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5138 236
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea) ✓	90-Start up Operation	5115 269
D3913-3 ✓	Rib	1 pcs (1 ea) ✓	90-Start up Operation	5139 345
D3913-7 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5136 111
D3913-9 ✓	Hinge Rib	1 Ea (1 ea) ✓	90-Start up Operation	5133 177
D3916-041 ✓	Rib Assembly	2 Ea (2 ea) ✓	90-Start up Operation	5142 401
D3916-5 ✓	Light Rib	3 Ea (3 ea) ✓	90-Start up Operation	5141 287
D4016-1 ✓	Hinge Half, Base	3 pcs (3 ea) ✓	90-Start up Operation	5115 309
D4017-7 ✓	Rib	3 pcs (3 ea) ✓	90-Start up Operation	5123 991
D4017-9 ✓	Rib	2 pcs (2 ea) ✓	90-Start up Operation	5141 346

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

D4020-11	End Mesh, Basket	2 pcs (2 ea)	90-Start up Operation	IXS133429/IXS133427
D4021-1	Handle Plate	3 pcs (3 ea)	90-Start up Operation	S126559
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	S138258
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	S138521
D4672-1	Blanking Plate	2 pcs (2 ea)	90-Start up Operation	S126705
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	S109214
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	4X5106952/2X5132304-1
D2931	Bumper	2 pcs (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	S076007
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	S094592
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	S133206-1
D4021-5	Blanking Plate	2 pcs (2 ea)	150-HandFinish	IXS118039/IXS144379
NAS1149FN832P	Washer	2 Ea (2 ea)	150-HandFinish	S136368-1

M.D. 007632

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	15	0
	D3913-1	1	7	0
	D3913-15	1	3	0
	D3913-3	1	6	0
	D3913-7	2	10	0
	D3913-9	1	6	0
	D3916-041	2	2	0
	D3916-5	3	13	0
	D4016-1	3	174	0
	D4017-7	3	11	0
	D4017-9	2	14	0
	D4020-11	2	5	0
	D4021-1	3	10	0
	D4034-041	1	2	0
	D4034-043	1	2	0
	D4672-1	2	6	0
	M304EX0.75-16F	33	1,500	0
150-HandFinish	AN3-10A	6	265	0
	D2931	2	837	0
	D4021-5	2	9	0
	MS20600-AD4W3	2	249	0
	MS21042L3	6	2,545	0
	NAS1149F0332P	12	2,556	0
	NAS1149FN832P	2	2,016	0

Part Specifications

Specifications could not be found.

Plex 1/4/19 11:09 AM Dart.lajeunesse.marie



Container No: S143826



Part: D3913-041

Job No: 188195

Serial No/Batch: S143826

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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www.dartaerospace.com

Date: 01/10/19

Entered: _____ Date: _____



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NCR No. _____

Route update only ☐

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Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					